

Date: Monday, 1/14/2008 2:37:42 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 36756	
Estimate Number : 12108	
P.O. Number :	Part Number : D32013
This Issue : 1/14/2008 S.O. No. :	Drawing Number : D3201 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 32474	Material :
Written By :	Due Date : 2/5/2008 Qty: 40 Um: Each
Checked & Approved By : <u>08 01 15</u>	
Comment :	
Est Rev: A Removed from 9 Digit 06-01-25 JLM	
Est Rev: B Now on Waterjet 06-08-14 JLM	
Est Rev C added scribing NCR262 07.11.29 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.0473 sf(s)/Unit Total : 1.8900 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.050" thick
 (M2024T3S.050)
 Batch: 105646 IB 8-1-16

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3201
 Dwg Rev: B
 Prog Rev: B

IB 8-1-16

(46)

2-Deburr if necessary

08/01/17 (46)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-1-16

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08/01/17 (46)

caentes

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr Stack

u 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:37:42 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 36756

Part Number: D32013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Bend as per Dwg D3201

SB 08/01/18 (46)

2-Scribe part# and Batch# per dwg D3201

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/18

(46)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

write this in

08-01-21 (46)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/01/21 (46)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5776

08/01/21 (46)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.22

Job Completion



u 08.01.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

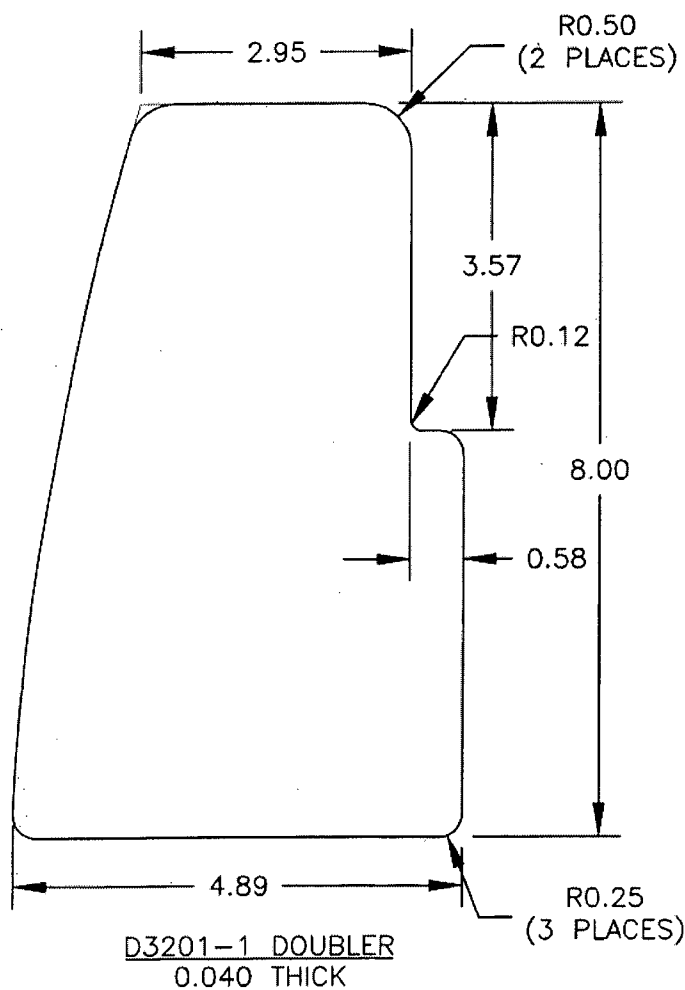
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

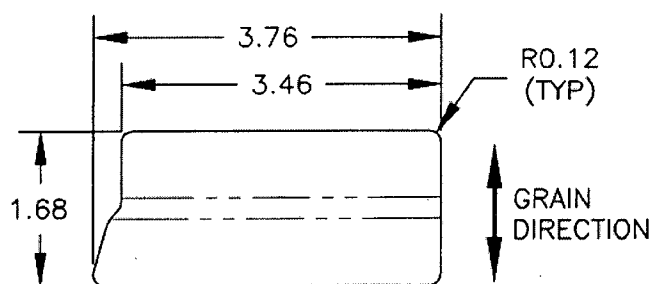


DESIGN		DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D3201	REV. B SHEET 1 OF 1
DATE	03.11.03		TITLE	DOUBLER	SCALE 1:2
A	03.08.07	NEW ISSUE			
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4			

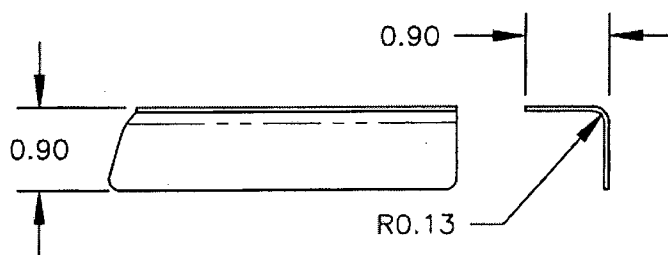
RELEASED
03.11.14



D3201-1 DOUBLER
0.040 THICK



D3201-3/-4 ANGLE
(FLAT PATTERN)



D3201-3 ANGLE (SHOWN)
D3201-4 ANGLE (BEND OPPOSITE)
0.050 THICK

D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. 36756

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